

Split

# Work Order ID 64802-1



Friday, December 17, 2010 7:57:53 AM

Item ID: D2348

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 12/16/2010 Start Qty: ~~12.00~~ 812



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten initials*

Date:

*12/17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2348

Rev C

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2348

*6061 - 063*

Dwg Rev: *5*

Prog Rev: *2*

2-Debur if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

*Subsides*

*(H6)*

*Bld-1-3*

*Bld-1-3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo  
Debur

0.00

N/A 0.00

11.01.04

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

N/A 0.00

11.01.04

150



Outsource4

Outsource process - Anodize

Outsource process-Anodize per QSI017 4.1.10.1

Memo

Issue P/O: 13226

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

0.00

0.00

CL 11/01/06 (16)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure certificate of conformity is attached

PC 11/16/17 (14)

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

INSPECT CERTS

Sub 117

(16)

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Install Insert as per Dwg D2348

ES 11/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/02/07

412

200

Identify as per dwg &amp; Stock Location: 11

0.00



Packaging

Memo

0.00

Packaging

11/2/07 (120)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/14

MF  
11-02-01

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, December 17, 2010 7:57:57 AM

Page 1

Work Order ID: 64802

Parent Item: D2348

Parent Item Name: Wearplate

Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM  
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	148.6340	0.0198	0.250105			
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6061-T6 .063 Sheet



BH-1-3

Location	Loc Qty	Loc Code
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MAT	111	
-----	-----	--

116308	111	
--------	-----	--

MAT21	37.634	
-------	--------	--

113608	37.634	
--------	--------	--

D3996-FE-832-EF		Manufactured	No
-----------------	--	--------------	----



Self-Clinching Fastener

180	Each	61.0000	4	48
-----	------	---------	---	----



Location	Loc Qty	Loc Code
----------	---------	----------

ST107	61	
-------	----	--

54162	61	
-------	----	--

Ep 50/02/04  
416799 (460)  
48-2 1365462

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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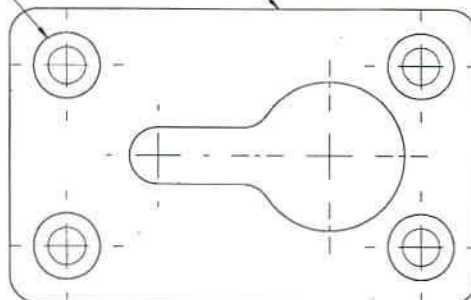
**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLA. PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF  
SELF-CLINCHING FASTENER  
4 PL

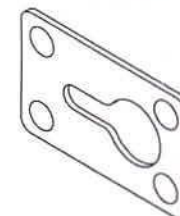
D2348F



**D2348 WEAR PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64802

*B/10-12-17*



**RELEASED**  
2009-11-09  
*MD*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW. ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO B-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>99</i>		
CHECKED	<i>DS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DS</i>	D2348	SHEET 1 OF 2
APPROVED	<i>DS</i>	TITLE	SCALE
DE APPR.	<i>DS</i>	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

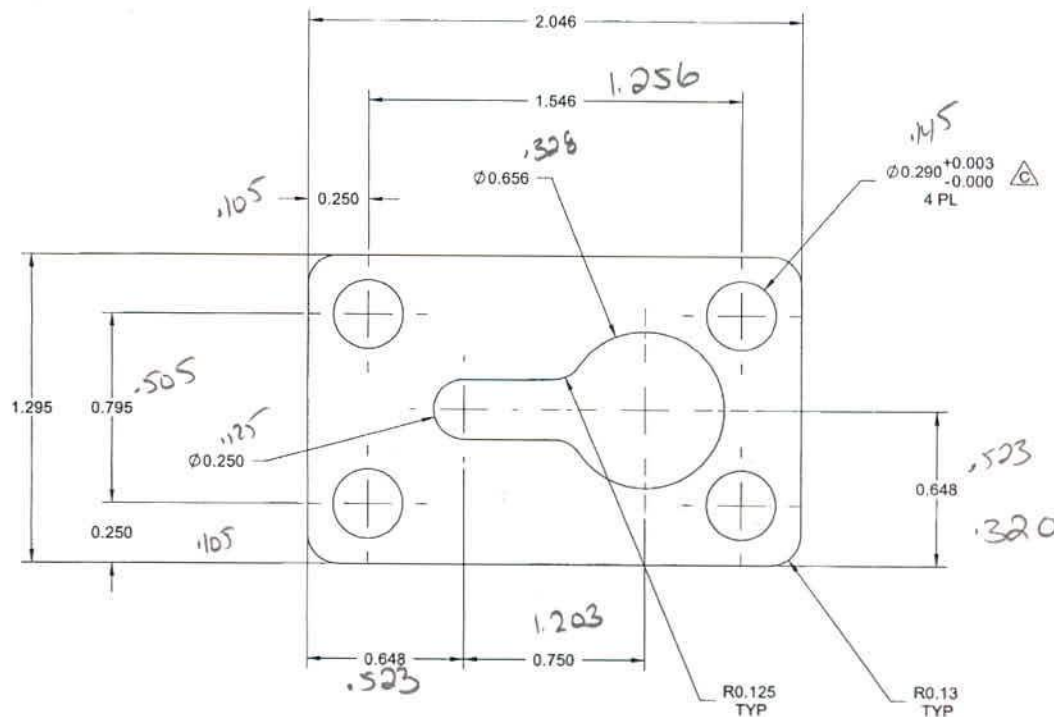
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**D2348F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED	15	DRAWING NO.	REV. C
MFG. APPR.	15	<b>D2348</b>	SHEET 2 OF 2
APPROVED	15	TITLE	SCALE
DE APPR.	15	<b>WEAR PLATE</b>	NTS
DATE	09.10.01	COPYRIGHT © 1999 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2009-11-08  
MD

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13226

Purchase Order Date 1/06/11

PO Print Date 1/06/11

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.  
21 AVIATION ROAD  
POINTE CLAIRE, QC H9R 4Z2  
CA

Contact Name

Vendor Phone

514 429 7777

Vendor Fax

514 429 5108

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
C. Lavoie

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	64802	D2348 WEARPLATE	1/14/11 Yes	16.00	Purolator ground	\$6.2500	\$100.00

Special Inst: ANODIZE BLACK AS PER DWG D2348  
REV. C  
B64802  
FINISH BLACK ANODIZE AS PER MIL-A-  
8625-F TYPE I/ IB/IC/IIB  
CLASS 2

PO Total:

\$100.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 1/06/11

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



# Packing Slip

21 chemin de l'Aviation, Pointe-Claire  
QC H9R 4Z2  
Canada  
Phone: 514-429-7777 Fax: 514-429-5108  
Email: info@tnminc.ca

DATE

PACKING SLIP #

1/14/2011

- 88824



BILL TO:

SHIP TO:

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY ON K6A 1K7

No. De Commande/PO#	CUST	TERMS	REP	SHIP	VIA	F.O.B	JOB NUMBER
13226	0094	NET 30		1/14/2011	Purolator		130314-001

PO Line#: 1

QTY DUE	QTY SHIPPED	QTY B/O	DESCRIPTION
16	16	0	P/N: D2348 TNM-REV: P1 Minimum Charge

Sign Here: \_\_\_\_\_

En cas de perte ou de dommages dû à la valeur intrinsèque de certaines pièces, la responsabilité se limitera à deux fois la valeur du traitement des pièces perdues ou endommagées.  
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

Packing Slip PACK01 REV: PACK01



# Anodisation & Peinture TNM Inc

21 chemin de l'Aviation, Pointe-Claire QC H9R 4Z2  
Telephone 514-429-7777 Fax 514-429-5108  
AS9100 Rev B Certified QMS, Nadcap, Chemical & NDT

C of C: 88824



1/14/2011

CLIENT / CUSTOMER:

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY ON K6A 1K7

PURCHASE ORDER /  
NO. DE COMMANDE:

13226

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION PROTECTIVE FINISH CODES	PART PROCESS & TREATMENT
1	16	16	P/N:D2348 TNM-REV:P1 B64802 FITTING-WEARPLATE MAT'L: ALUMINUM	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

8/10/17

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.  
All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filled and are available for viewing upon request.  
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.  
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

9  
T.N.M.